

Date: Wednesday, 27/02/2008 7:40:20 AM  
 User: Linda Lacelle

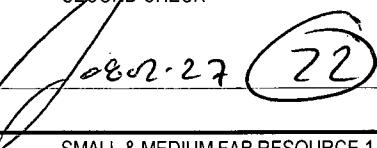
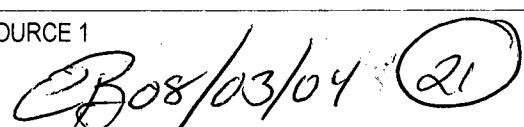
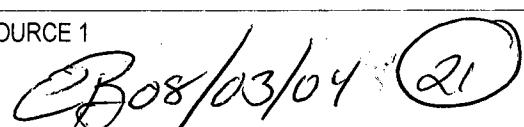
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET R/H		
Job Number	: 37636		Part Number	: D30722		
Estimate Number	: 11550		Drawing Number	: D3072 REV A1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 27/02/2008 S.O. No. :		Drawing Revision	: A1		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 14/03/2008 Qty: 20 Um: Each		
Previous Run	: 37636					
Written By	:					
Checked & Approved By	:					
Comment	: Est. B02.01.18 Flat pattern created on dash 101. NG Est Rev:C 08-02-26 now water jet DD verified by:LL					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S090	5052-H32 .090 Sheet  3
<b>Comment:</b> Qty.: 0.1225 sf(s)/Unit Total : 2.4507 sf(s) 5052-H32 .090 Sheet Batch <u>3019</u> <u>B 8-2-27</u>		
2.0	WATER JET	FLOW WATER JET  
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3072 (D3072-101 flat pattern) Dwg Rev: <u>A1</u> <u>B 8-2-27</u>  Prog Rev: <u>A1</u>		
2-Deburr if necessary <u>B 8-2-27</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE  <u>B 8-2-27</u>		
4.0	QC8	SECOND CHECK  
<b>Comment:</b> SECOND CHECK  <u>10802-27</u> 		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1  <u>0803/04</u> 		
1- deburr if necessary  <u>0803/04</u> 		
2- Bend as per dwg D3072  <u>0803/03</u> 		

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET R/H

Job Number: 37636

Part Number: D30722

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>✓ 08/03/06 (21)</i>
Comment: INSPECT WORK TO CURRENT STEP		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<i>(21)</i>
Comment: HAND FINISHING RESOURCE #1		
	Chemical Conversion Coat as per QSI 005 4.1	<i>MF 08-03-05</i>
8.0	POWDER COATING	POWDER COATING
	<i>M 100700</i>	<i>(21)</i>
Comment: POWDER COATING		
	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	<i>MF 08/03/06</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>(21)</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
10.0	PACKAGING 1	PACKAGING RESOURCE #1
	<i>BR 08-03-06</i>	<i>(21)</i>
Comment: PACKAGING RESOURCE #1		
	Identify and Stock	
	Location: <i>3763</i>	<i>BR 08/03/06 (21)</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE
	<i>BR 08/03/06</i>	<i>(21)</i>
Comment: FINAL INSPECTION/W/O RELEASE		

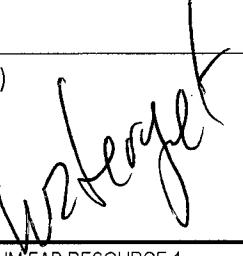
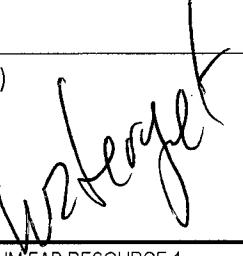
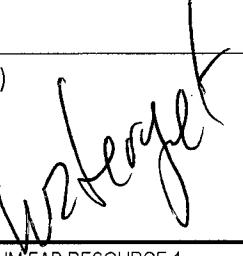
Job Completion



*BR 08/03/06*

Date: Tuesday, 2/26/2008 8:02:17 AM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET								
Job Number	37636											
Estimate Number	11550											
P.O. Number	:		Part Number	D30722								
This Issue	2/26/2008	S.O. No. :	Drawing Number	D3072 REV A1								
Prsht Rev.	NC		Project Number	N/A								
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	A1								
Previous Run	:		Material	:								
Written By	:		Due Date	3/14/2008								
Checked & Approved By	<u>1/10/08 02 26</u>		Qty:	20								
Comment	Est. B	02.01.18	Flat pattern created on dash 101.	NG								
<b>Additional Product</b>												
Job Number: 												
Seq. #:	Machine Or Operation:	Description :										
1.0	D3072101 	Bracket (flat) 										
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Bracket (flat) Pick: <table border="1"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D3072-101</td> <td>Bracket</td> <td></td> </tr> </table>					Qty	Part Number	Description	Batch	1	D3072-101	Bracket	
Qty	Part Number	Description	Batch									
1	D3072-101	Bracket										
2.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 										
Comment: SMALL & MEDIUM FAB RESOURCE 1 Bend as per dwg D3072 Dash 1 bending detail (LH)												
3.0	QC5 	INSPECT WORK TO CURRENT STEP 										
4.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 										
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1												
5.0	POWDER COATING 	POWDER COATING 										
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/03	5	I part was snap out of Tolerance	<i>AB</i> <i>AB</i>	Strip & destroy	AB 08/03/03	<i>AB</i> 08-03-03	<i>AB</i> 08/03/03	<i>AB</i> 08/03/03

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37636

Part Number: D30722

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

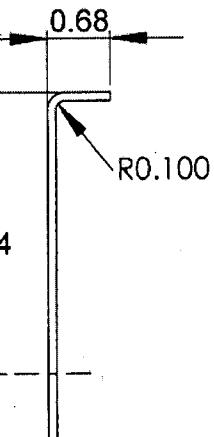
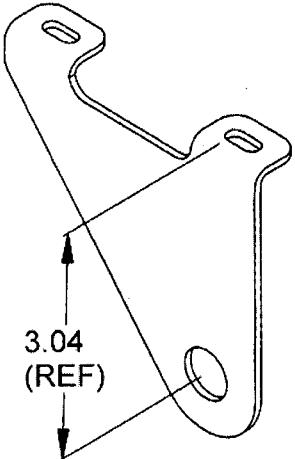
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ISSUED  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3072	SHEET 1 OF 1
DATE	01.12.16	TITLE	SCALE
A	01.12.16	BRACKET	1:1



#### D3072-1/2 BRACKET

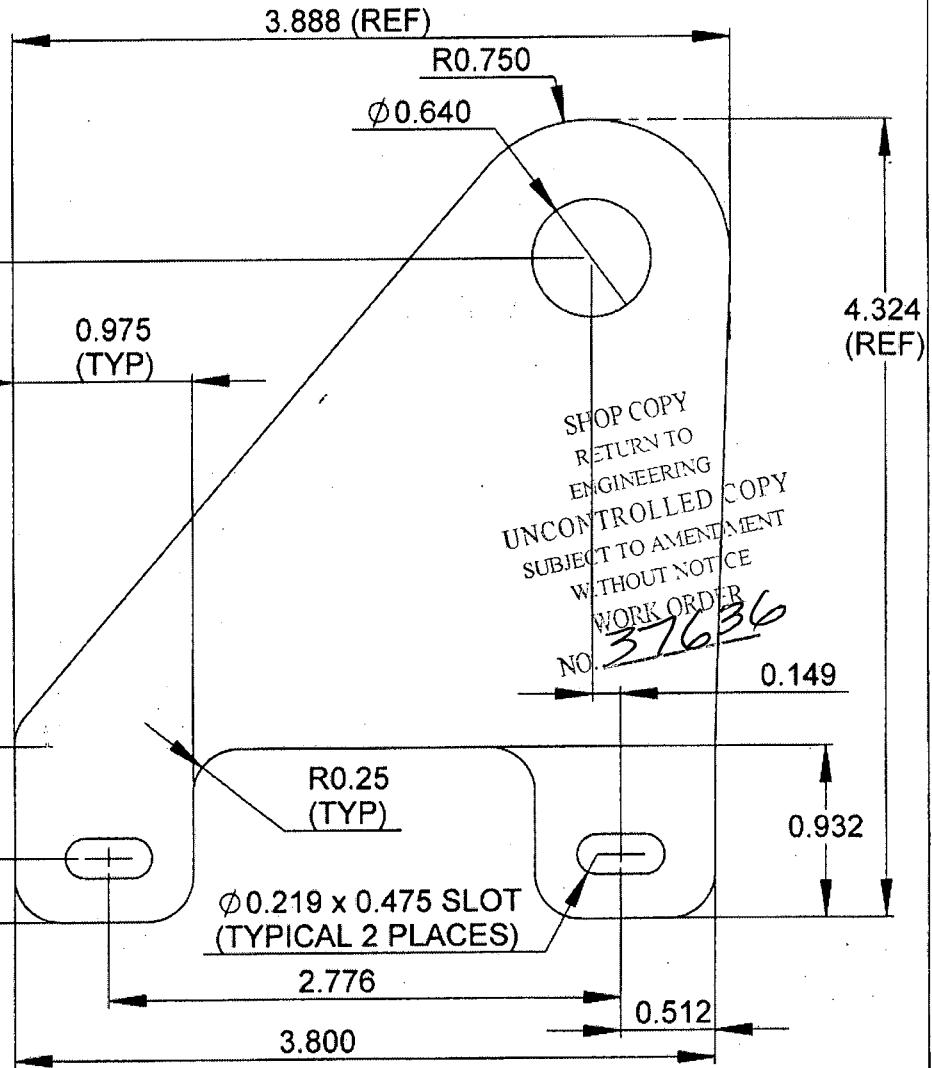
- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/ QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COATBLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL  
SCALE 1:2  
D3072-1 LH BRACKET SHOWN  
(D3072-2 BEND OPPOSITE)

RELEASED  
02.01.15

D3072-101

FLAT PATTERN FOR D3072-1/2



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DART AEROSPACE LTD	Work Order:	37636
Description: BRACKET R/H	Part Number:	D3072-2
Inspection Dwg: D3072-2 Rev: A1		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by: <u>LB</u>	Audited by: <u>  </u>	Prototype Approval: <u>  </u>
Date: <u>8-2-07</u>	Date: <u>08-02-07</u>	Date: <u>  </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	